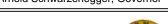
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-013411 Address: 333 Burma Road **Date Inspected:** 18-Apr-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

Jhou Cheng **CWI Name: CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component: OBG** Components

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#19

During random in process inspection this QA inspector observed 160mm long aligned porosity on the weld. The welding was performed by FCAW welding process. The weld is identified as USPL1-507-001 and the component is OBG component. The porosity was removed by carbon arc gouging and weld was re welded by same process with applicable WPS.

For further information, please find attached pictures below.

Bay#19

FCAW welding of weld joint USPL1-507/508-001, 002 located on USPL1-507/508. Welder is identified as 062761 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint USPL1-509/510-001, 002 located on USPL1-509/510. Welder is identified as 062807 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint USPL1-511/512-001, 002 located on USPL1-511/512. Welder is identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

060752 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint USPL1-513/514-001, 002 located on USPL1-513/514. Welder is identified as 062703 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint USPL1-515/516-001, 002 located on USPL1-515/516. Welder is identified as 062786 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.





Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel, Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon, Timothy	QA Reviewer